

Split

Work Order ID 126524 -2

126524

Page 1

Item ID: D3649-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tunnel Bottom Panel Assy

Start Date: 11/12/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/12/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 14-11-12 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3649

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3649 Dwg Rev: 6 Prog Rev: B 2-
Deburr if necessary

304.018

6

2

DAS
23
9-89

14-11-13

PRO

→

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

6

2

DAS
23
9-89

14-11-13

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

6

DAS
23
9-89

NOV 14 2014

Work Order ID 126524

Wednesday, November 12, 2014 10:37:43 A

126524

Page 2

Item ID: D3649-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Tunnel Bottom Panel Assy

Stop ***NS2***

Start Date: 11/12/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/12/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3649

0.00

0.00

Tool ID

Tool #

Plan
Code

DAS

30

9-89

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11/12/14

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS

38

9-89

DEC 17 2014

150

150

Small Fab

Small Fab

Small Fab

Memo

1- Form dimple for MS20427M3 rivet per dwg D3649*****ensure dimples are on the proper side*****2-Assemble nutplates as per dwg D3649

0.00

0.00

DAS

36

9-89

11/12/14

Work Order ID 126524

Wednesday, November 12, 2014 10:37:43 A

126524

Page 3

Item ID: D3649-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tunnel Bottom Panel Assy

Start Date: 11/12/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/12/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

DAS
30
9-89

1

14/12/18

170

Identify as per dwg & Stock Location: ST

0.00

170

Packaging

Memo

0.00

Packaging

DAS
30
9-89

1

14/12/18

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

15/1/15

Dr-12-19

Picklist Print

Wednesday, November 12, 2014 10:37:49 AM

Page 1

Work Order ID: 126524

126524

Parent Item: D3649-041

D3649-041

Parent Item Name: Tunnel Bottom Panel Assy

Start Date: 11/12/2014

Required Date: 11/12/2014

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-09-26 EC verified by: DD
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C Ecn1162 08-04-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20427M3-3 *MS20427M3-3* Rivet		Purchased	No			110	Each	608.0000	88	440		14/12/18	DAS 36 9-89

Location	Loc Qty	Loc Code
GA	10	
121114	10	
ST311	598	
m129864	598	

M304S26GA

M304S26GA

304/316 0.018 SHEET

Purchased No

150 sf 260.2272 6.069

**

DAS
23
9-89

Location	Loc Qty	Loc Code
MAT020	260.2272	
122753	26	
123135	54.689	
m130650	179.5382	

MS21060-3K

MS21060-3K

Nut Plate

Purchased No

150 Each 98.0000 22

**

130650
110

Location	Loc Qty	Loc Code
ST302	98	
m129864	66	
m129913	32	

22

DAS
36
9-89

Picklist Print

Wednesday, November 12, 2014 10:37:49 AM

Page 2

Work Order ID: 126524

126524

Parent Item: D3649-041

D3649-041

Parent Item Name: Tunnel Bottom Panel Assy

Start Date: 11/12/2014

Required Date: 11/12/2014

Start Qty: 5.00

Required Qty: 5.00

MS21062-3K

Purchased

No

150

Each

68.0000

22

110

MS21062-3K

Nut Plate

**

14/12/18
DAS
36
9-89

Location

Loc Qty

Loc Code

ST302

68

124316

3

124329

1

M129913

14

M130822

50

22

DART AEROSPACE LTD		Work Order:	176524
Description: Tunnel Bottom Panel		Part Number:	D3649-1
Inspection Dwg: D3649	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098	-		✓	Jkmo
Ø0.196	+0.005/-0.001	0.196	-		✓	
Ø0.250	+0.005/-0.001	0.252	-		✓	
0.400	+/-0.010	0.400	-		✓	
0.385	+/-0.010	0.385	-		✓	
0.250	+/-0.010	0.250	-		✓	
44.57	+/-0.030	44.57	-		T	
11.70	+/-0.030	11.70	-		✓	Jkmo
3.370	+/-0.030	3.370	-		✓	
13.76	+/-0.030	13.76	-		T	Jkmo
4.300	+/-0.010	4.300	-		✓	
10.11	+/-0.030	10.11	-		✓	
12.90	+/-0.030	12.90	-		T	
16.61	+/-0.030	16.61	-		T	
15.80	+/-0.030	15.80	-		T	
3.950	+/-0.010	3.950	-		✓	
0.42	+/-0.030	0.42	-		✓	
0.41	+/-0.030	0.41	-		✓	
0.85	+/-0.030	0.85	-		✓	
19.64	+/-0.030	19.64	-		T	
0.54	+/-0.030	0.54	-		✓	
1.400	+/-0.010	1.400	-		✓	
2.63	+/-0.030	2.63	-		✓	
2.93	+/-0.030	2.93	-		✓	
1.49	+/-0.030	1.49	-		✓	
5.98	+/-0.030	5.98	-		✓	
0.54	+/-0.030	0.54	-		✓	
2.20	+/-0.030	2.20	-		✓	
2.75	+/-0.030	2.75	-		✓	
2.48	+/-0.030	2.48	-		✓	

DART AEROSPACE LTD		Work Order:	126524
Description: Tunnel Bottom Panel		Part Number:	D3649-1
Inspection Dwg: D3649	Rev: B	Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.16	+/-0.030	1.16"	-		✓	
3.38	+/-0.030	3.38"	-		✓	
2.00	+/-0.030	2.00"	-		✓	
0.90	+/-0.030	0.90"	-		✓	
16.64	+/-0.030	16.64"	-		✓	
0.48	+/-0.030	0.48"	-		✓	
13.80	+/-0.030	13.80"	-		✓	
0.46	+/-0.030	0.46"	-		✓	
11.76	+/-0.030	11.76"	-		✓	
1.23	+/-0.030	1.23"	-		✓	
0.88	+/-0.030	0.88"	-		✓	
18.46	+/-0.030	18.46"	-		✓	
5.23	+/-0.030	5.23"	-		✓	
1.932	+/-0.010	1.932"	-		✓	
1.943	+/-0.010	1.943"	-		✓	
5.02	+/-0.030	5.02"	-		✓	
1.820	+/-0.010	1.820"	-		✓	
0.70	+/-0.030	0.70"	-		✓	
2.100	+/-0.010	2.100"	-		✓	
2.33	+/-0.030	2.33"	-		✓	
0.94	+/-0.030	0.94"	-		✓	
3.30	+/-0.030	3.30"	-		✓	
1.900	+/-0.010	1.900"	-		✓	
0.61	+/-0.030	0.61"	-		✓	

Measured by:	DAS 23 9-89
Date:	14-11-13

Audited by:	DAS 38 9-89
Date:	NOV 14 2014

Prototype Approval:	N/A
Date:	N/A

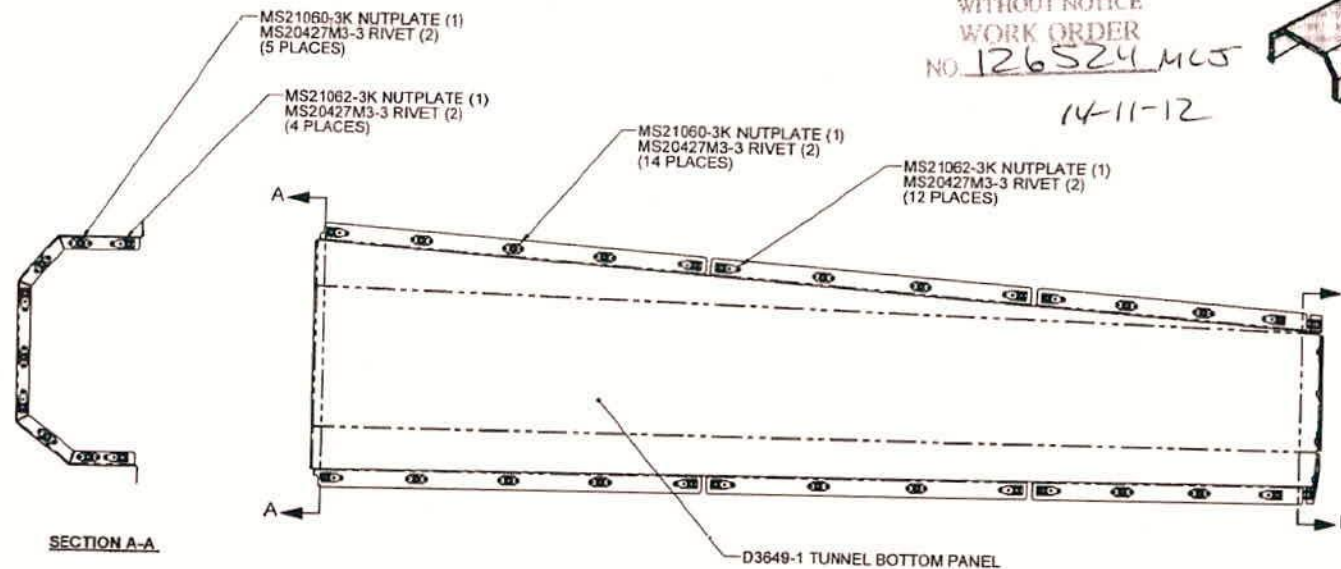
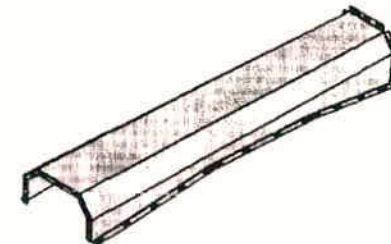
Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	

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WORK ORDER

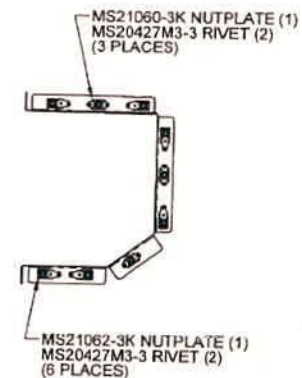
NO. 126524 MJS

14-11-12



SECTION A-A

D3649-1 TUNNEL BOTTOM PANEL



SECTION B-B

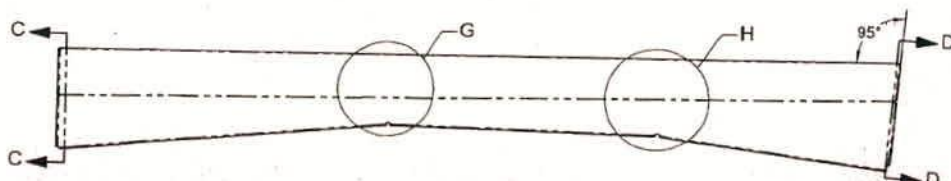
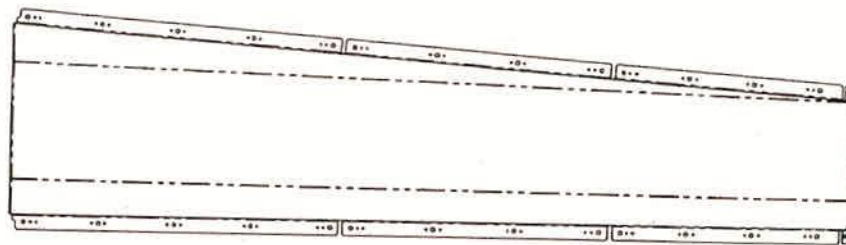
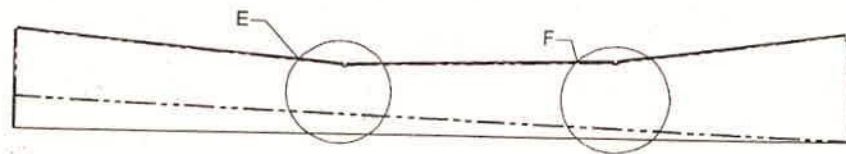
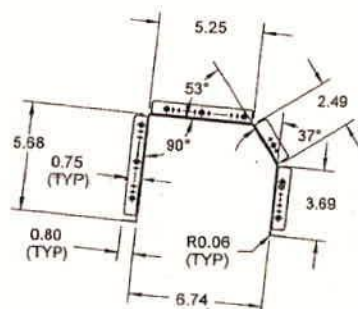
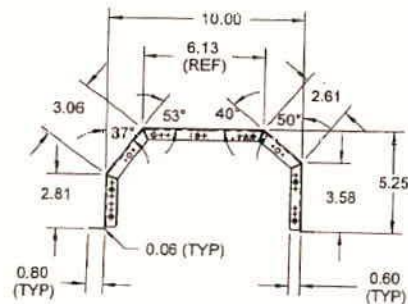
D3649-041 BOTTOM PANEL ASSEMBLY

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3649-041	TUNNEL BOTTOM PANEL ASSY.
1	D3649-1	TUNNEL BOTTOM PANEL
88	MS20427M3-3	RIVET
22	MS21060-3K	NUTPLATE
22	MS21062-3K	NUTPLATE

RELEASED
28-03-28 MJS

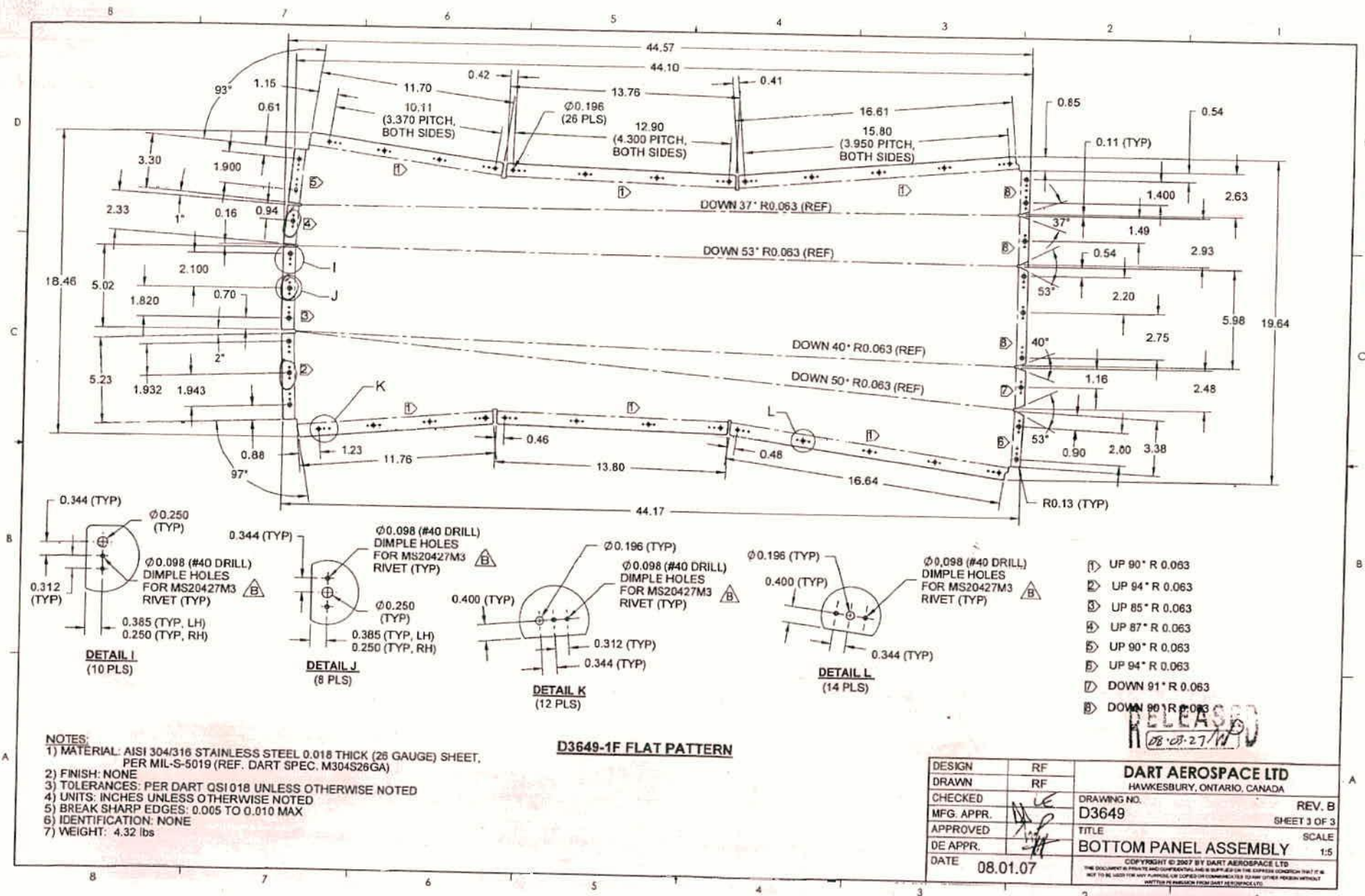
B	PAGE 3: MS20427M3 WAS MS20427M-3	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	IE	D3649	SHEET 1 OF 3
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APPROVED	MS	BOTTOM PANEL ASSEMBLY	1:5
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D3649-1 TUNNEL BOTTOM PANEL
(MAKE FROM D3649-1F)

RELEASED
08-01-07

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MFG. APPR.	LE	D3649	SHEET 3 OF 3
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